

AWC-022



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

POSITIVE RECALL

EFFECTIVE 19/6/14 AUTH SAP 9-89
RELEASED *MD* DATE 4-26-2019

DAS
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9-89

6F9540V00231

Job Sheet R198314



Part No: 6F9540V00231

Job Qty: 1 pcs

Part Name: AW169 Lower Cutter Installation Assembly



Part Weight: 0 lbs

Status: New

Job Created: 7/24/19

Job Tracking No:

Due Date: 8/9/19

Created By: Linda Lacelle

Type: Rework

Description:

Note: URF16-692 DWG IIN-D169-841 REV D IPP REV:A 13.11.13 NEW ISSUE DD VERF:JLM

Ship Via:

U/R

Priority: Medium

SAM
19/07/24

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1		8/9/19	0.00	0.00	Packaging 1 - 1		
		pcs					Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		

AB 19-7-25



DART Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Container No: S200484



Part: 6F9540V00231

Job No: R198314

Serial No/Batch: S200484

Revision: D

Inspector:

Exp Date:

Instructions:

Date: 07/25/19

Plax 7/24/19 3:20 PM dart.lacelle.linda

					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
115 Small Fab - 2 - B4B	1 pcs	8/9/19	0.00 1.00	Small Fab - 1 - B4B		
				Small Fab - 2 - B4B		
				Small Fab - 3 - B4B		
				Small Fab - 4 - B4B		
				Small Fab - 5 - B4B		
				Small Fab - 6 - B4B		AB 19-7-25
				Small Fab - 7 - B4B		
120 Conventional Mill - 1 - B4B	1 pcs	8/9/19	0.25 0.33	Conventional Mill - 1 - B4B		
				Conventional Mill - 2 - B4B		
125 QC 5	1 pcs	8/9/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
				QC 5 - 61		
				QC 5 - 81		
130 Outsource - 4 - Anodize	1 pcs	8/9/19	0.00 0.00	ATG001		
135 Packaging 2-1 - Recelve - B4B	1 pcs	8/9/19	0.00 0.00	Packaging 2 - 1 - B4B		
				Packaging 2 - 2 - B4B		
				Packaging 2 - 3 - B4B		
				Packaging 2 - 5 - B4B		
				Packaging 2 - 4 - B4B		
				Packaging 2 - 6 - B4B		
				Packaging 2 - 7 - B4B		
				Packaging 2 - 8 - B4B		
				Packaging 2 - 9 - B4B		
				Packaging 2 - 10 - B4B		
				Packaging 2 - 11 - B4B		
				Packaging 2 - 12 - B4B		
				Packaging 2 - 13 - B4B		
				Packaging 2 - 14 - B4B		
				Packaging 2 - 15 - B4B		
				Packaging 2 - 16 - B4B		
				Packaging 2 - 17 - B4B		
				Packaging 2 - 18 - B4B		
				Packaging 2 - 19 - B4B		
				Packaging 2 - 20 - B4B		
				Packaging 2 - 21 - B4B		
				Packaging 2 - 22 - B4B		
				Packaging 2 - 23 - B4B		

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KY 2019-0729

DP JUL 30 2019

					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
140	QC 6	1 pcs	8/9/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	JUL 30 2019
					QC 6 - 81	
145	Small Fab - 3 - B4B	1 pcs	8/9/19	0.00 0.50	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	AB 19-7-30
					Small Fab - 7 - B4B	
150	QC 5	1 pcs	8/9/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	AUG 01 2019
					QC 5 - 61	
					QC 5 - 81	
170	QC 4	1 pcs	8/9/19	0.00 0.00	QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	DAS 75 9-89
					QC 4 - 68	
					QC 4 - 72	
					QC 4 - 74	
					QC 4 - 75	
180	Packaging 3-1 - Stock - B4B	1 pcs	8/9/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	DAS 75 9-89
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Plex 7/24/19 3:20 PM dart.lacelle.linda	

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JUL 30 2019

AB 19-7-30

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AUG 02 2019

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See
Marched
for Concessions
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Aug 2, 2019

See Harcel for Concessions DAS 55 9-89 Aug 2, 2019				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
	190 DC - 1 - B4B	1	8/9/19	0.00 0.00	DC - 1 - B4B	JK JK
		pcs			DC - 2 - B4B	
	200 QC 21 - FG	1	8/9/19	0.00 0.00	QC 21 - FG - 21	
		pcs			QC 21 - FG - 70	
					QC 21 - FG - 53	

Part Op 110 - PULL FROM STOCK

Descriptions: 115 - REMOVE D4842-041 OUT FROM KIT, DISASSEMBLE AND KEEP HARDWARE TO REASSEMBLE.

120 - FACE DOWN (0.005") EACH D4842 AS PER DWG AND DEBURR.

125 - QC5- Inspect part completeness to step on W/O

130 - Issue P/O : 44131 AS PER DWG D4842 HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, PRIME IAW MIL-P-23377 J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005. C OF C IS REQUIRED

145 - REASSEMBLE USING ORIGINAL HARDWARE AS PER DWG Assemble as per dwg and apply loctite 598 on all faying surfaces.

170 - (QC4- 100% Inspect kits for completeness)

180 - Identify and pack for shipping as per PPP 6F9540V00231

190 - Photocopy blue file per PPP D169-841-015 chg002 and create labels per 6F9540V00231 CHG002

200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
6F9540V00231 MS21042L08 MS27037-08-19	AW169 Lower Cutter Installation Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5195595 5193154 5006768

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	6F9540V00231	1	4	0

Part Specifications

Specifications could not be found.

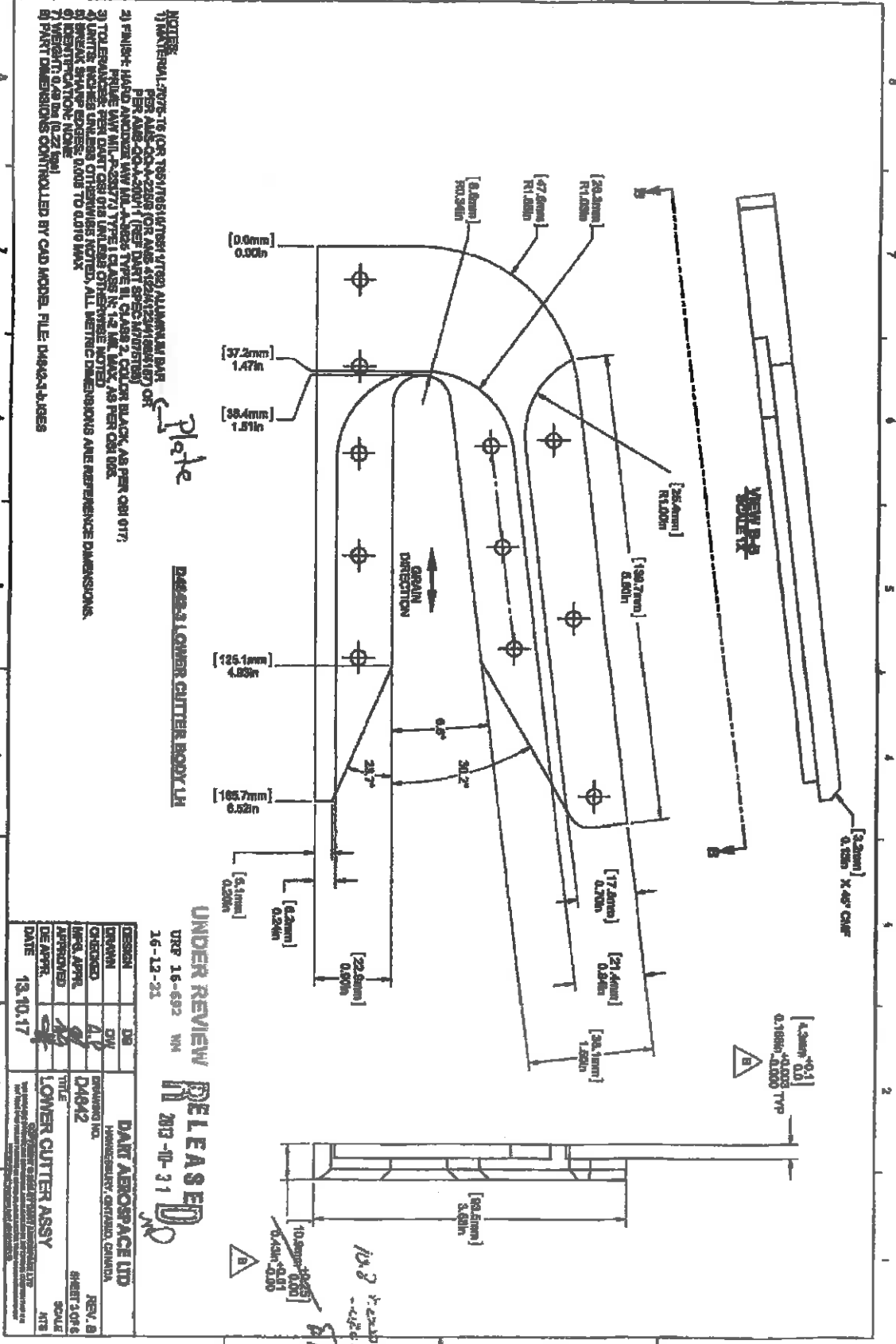


Dart Hawkesbury
1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada
Tel (613) 632-5200
Fax 613 632-5246

Inventory

Operation Number	Operation	Container No	Job	Master Unit Number	Quantity	Weight	Serial No/Batch	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No	Expiration Date	Invent Typ
Part Number: 6F9540V00231 Revision: AW169 Lower Cutter Installation Assembly																	
200	QC 21 - FG	S171709	192034		1 pcs	0	S171709	GA026		Stock	4/11/2019	*					False
		S195550	192031		1 pcs	0	S195550	Concession	Bin	Stock	7/3/2019	*			CHG002		False
		S195594	192032		1 pcs	0	S195594	Concession	Bin	Concession	7/3/2019	*			CHG002		False
		S195595	192030		1 pcs	0	S195595	Concession	Bin	Concession	7/3/2019	*			CHG002		False
Operation Totals:		4			4	0											
Part Totals:		4			4	0											
Totals:		4			4	0											

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NOTES:

- 1) MATERIAL: 7075-T6 (OR 7050-T6/7050-T7/62 ALUMINUM BAR)
- 2) FINISH: HAND ANODIZE W/ MIL-A-8626 TYPE II, CLASS 2, COLOR BLACK, AS PER ORG 017;
- 3) TOLERANCES: PER DAT 017 (SEE TYPICAL DIMENSIONS) UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 4) WEIGHT: 0.42 LB (0.22 kg)
- 5) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: DA62-3-01-005

UNDER REVIEW

16-12-21

DRP 16-692 WH

RELEASED

2013-10-31

DESIGN	DATE	BY	DATE	BY
DRAWN	13.10.17	DAW		
CHECKED		AW		
INSTR. APPR.		AW		
APPROVED		AW		
DATE	13.10.17			

DAIT AEROSPACE LTD

MANUFACTURED BY: GIFFORD, CANADA

REV. B

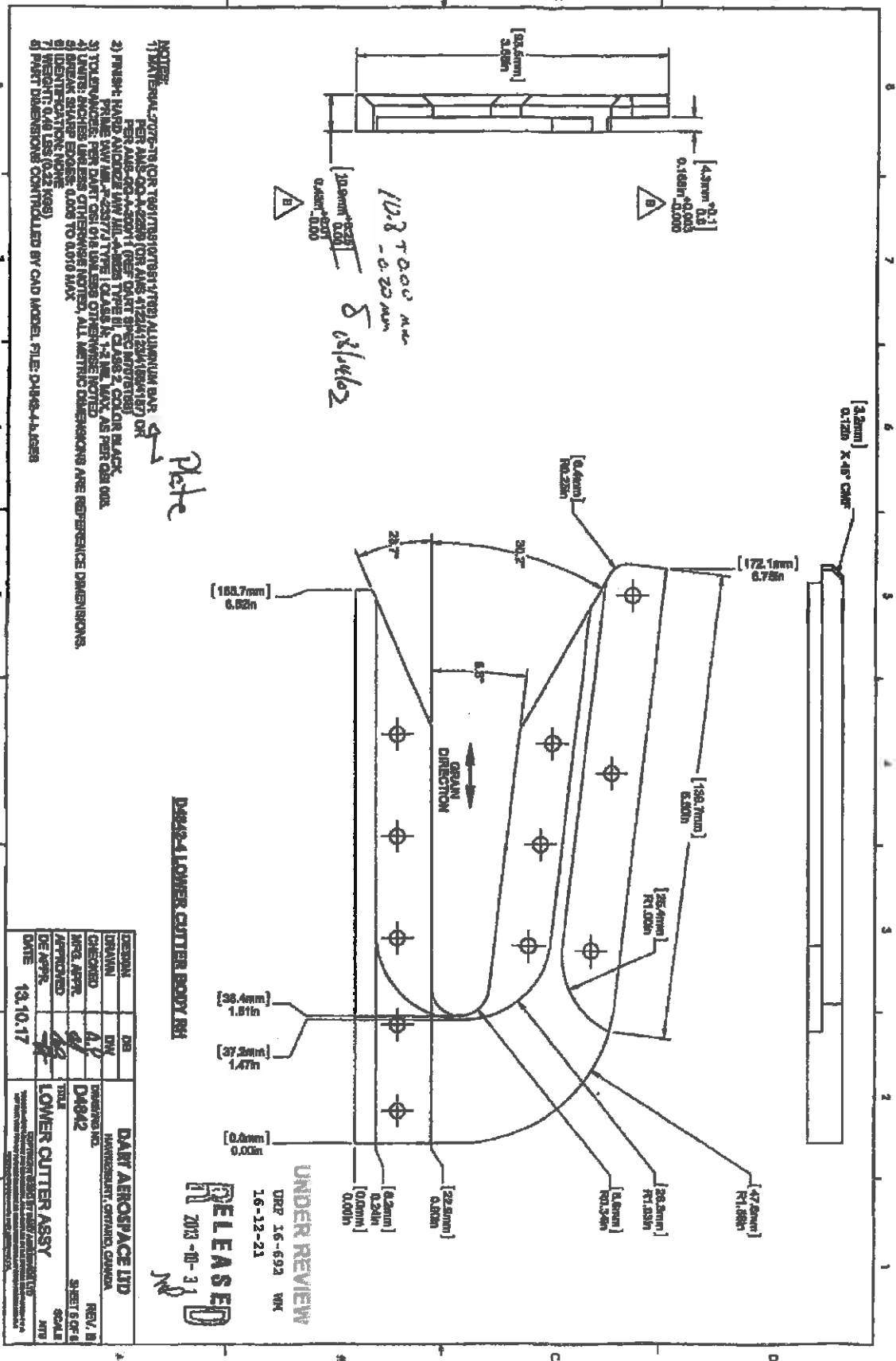
DA62

TITLE

LOWER CUTTER ASSY

SCALE

1:1



D464 LOWER CUTTER BODY RH

RELEASED
2013-10-31

UNDER REVIEW
D464-4.1.XB38
16-12-23

DESIGN	REV	DATE	DESCRIPTION
DESIGNED	REV		DESIGNED
CHECKED	REV		CHECKED
APPROVED	REV		APPROVED
DATE	13.10.17		

DESIGN	REV	DATE	DESCRIPTION
DESIGNED	REV		DESIGNED
CHECKED	REV		CHECKED
APPROVED	REV		APPROVED
DATE	13.10.17		

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: <u>R198314</u> Part No. <u>CF9540100231</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: _____	Sequence #: _____	QTY Affected: _____	Disposition		DART (05/02/21) 51 9-89		
Description Work Order Deviation Remove 0.005 of Material from base face for the following Parts 04842-3 and 4842-4 (see attached Drawing) Measurement SA 0.425 0.000 + 0.002- also at assembly use bolt 3x and washer 3x at base of cable cutter. tighten snug for the time being when Sealant dries up. the remove bolts and washers			re-work 04842-041 as per attached instructions/drawing			Completed By <u>SC 19/07/25</u> Lead hand / Supervisor <u>19/07/25</u>	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐				
Other/Details:							



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044131



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044131

PO Date: 7/29/19

Due Date: 7/31/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments: ****RUSH****

E-MAILED
2019-07-30

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	R198348	D4842-3	Lower Cutter Body, LH Issue P/O : AS PER DWG D4842 HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, PRIME IAW MIL-P-23377 J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005. C OF C IS REQUIRED	Firmed	-	7/31/19	8 pcs	0 pcs	8 pcs	\$22.50/pcs	\$180.00
2	R198349	D4842-4	Lower Cutter Body, RH Issue P/O : AS PER DWG D4842 HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, PRIME IAW MIL-P-23377 J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005. C OF C IS REQUIRED	Firmed	-	7/31/19	4 pcs	0 pcs	4 pcs	\$22.50/pcs	\$90.00



PURCHASE ORDER
POHB044131



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	R198314	6F9540V00231	AW169 Lower Cutter Installation Assembly Issue P/O : AS PER DWG D4842 HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, PRIME IAW MIL-P- 23377 J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005. C OF C IS REQUIRED	Firmed	-	7/31/19	1 pcs	0 pcs	1 pcs	\$22.50/pcs	\$22.50
	R198313			Firmed	-	7/31/19	1 pcs	0 pcs	1 pcs	\$22.50/pcs	\$22.50
	R198312			Firmed	-	7/31/19	1 pcs	0 pcs	1 pcs	\$22.50/pcs	\$22.50
Sub Total:							3	0	3		\$67.50
4	R198330	D4842-041	Lower Cutter Assembly Issue P/O : AS PER DWG D4842 HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, PRIME IAW MIL-P-23377 J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005. C OF C IS REQUIRED	Firmed	-	7/31/19	1 pcs	0 pcs	1 pcs	\$22.50/pcs	\$22.50
Grand Total:											\$360.00

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044131



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/30/19 10:28 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918320

Date: 30-Jul-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
8 ea	Part: D4842-3 Lower Cutter Body, LH Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 25663 PO: POHB044131		Rev: B Line: 1
4 ea	Part: D4842-4 Lower Cutter Body, RH Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 25664 PO: POHB044131		Rev: B Line: 2
3 ea	Part: 6F9540V00231 AW169 Lower Cutter Instal Ass Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 25665 PO: POHB044131		Rev: Line: 3
1 ea	Part: D4842-041 Lower Cutter Assembly Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied),		Rev: B
Made in Canada.			

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A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918320

Date: 30-Jul-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	.0001-.0002" (1 - 2 mils) per drawing. Job: 25666 PO: POHB044131		
	Line: 4		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>JUL 30 2019</u> Certified Signature: <u>/</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

RECEIVED
JUL-30 2019
DART AEROSPACE LTD.